

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66947

Thursday, March 03, 2011 8:46:15 AM



Page 2

Item ID: D3283-1

Accept

Revision ID:

Item Name: Doubler

Setup

Start



Stop



Start Date: 3/3/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Deburr

0.00

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

*****ensure rivet fits in #30 (0.128") holes as per dwg *****

150



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Hand Finishing

Memo

0.00

Mar 29 4 11/05/14

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Work Order ID 66947

Thursday, March 03, 2011 8:46:15 AM



Page 3

Item ID: D3283-1**Accept****Setup****Start****Revision ID:****Item Name:** Doubler**Stop****Start Date:** 3/3/2011**Start Qty:** 20.00**Cust Item ID:****Required Date:** 3/11/2011**Req'd Qty:** 20.00**Customer:****Reference:****Approvals:** **Process Plan:** _____**Date:** _____**Tooling:** _____**Date:** _____**Run****Start****QC:** _____**Date:** _____**SPC (Y/N):** _____**Date:** _____**Stop****Sequence ID/
Work Center ID**

160



QC

Quality Control

**Operation
Description**

QC3- Inspect Part Finish

**Set Up/
Run Hours**

0.00

Tool ID**Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

29 4 01 11/03/11

170



Packaging

Packaging

Identify as per dwg & Stock Location:

45

0.00

count dec

11/3/11 29 sf

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/3/11 sf

MF
11-03-11

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Picklist Print

Thursday, March 03, 2011 8:46:24 AM

Page 1

Work Order ID: 66947



Parent Item: D3283-1



Parent Item Name: Doubler

Start Date: 3/3/2011

Required Date: 3/11/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A 04.09.28 New issue KJ/JLM

IPP Rev:B Now on Waterjet 07-05-28 JLM

IPP Rev:C As per Rev E 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased		No		100	sf	139.5000	0.2361	4.970526	7		

6061-T6 .063 Sheet



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	105.6	
116308	28.6	
116623	77	116623
MAT21	33.9	
113608	33.9	

(29)

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DART AEROSPACE LTD	Work Order:	66940
Description: Doubler	Part Number:	D3283-1
Inspection Dwg: D3283	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>B</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: <u>11-3-08</u>	Date: <u>11/3/08</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.11.23	New Issue	KJ/JLM	
B	07.06.04	Dimensions updated per Dwg Rev. D	KJ/JLM	
C	07.09.26	Dwg Rev updated	KJ/EC	22

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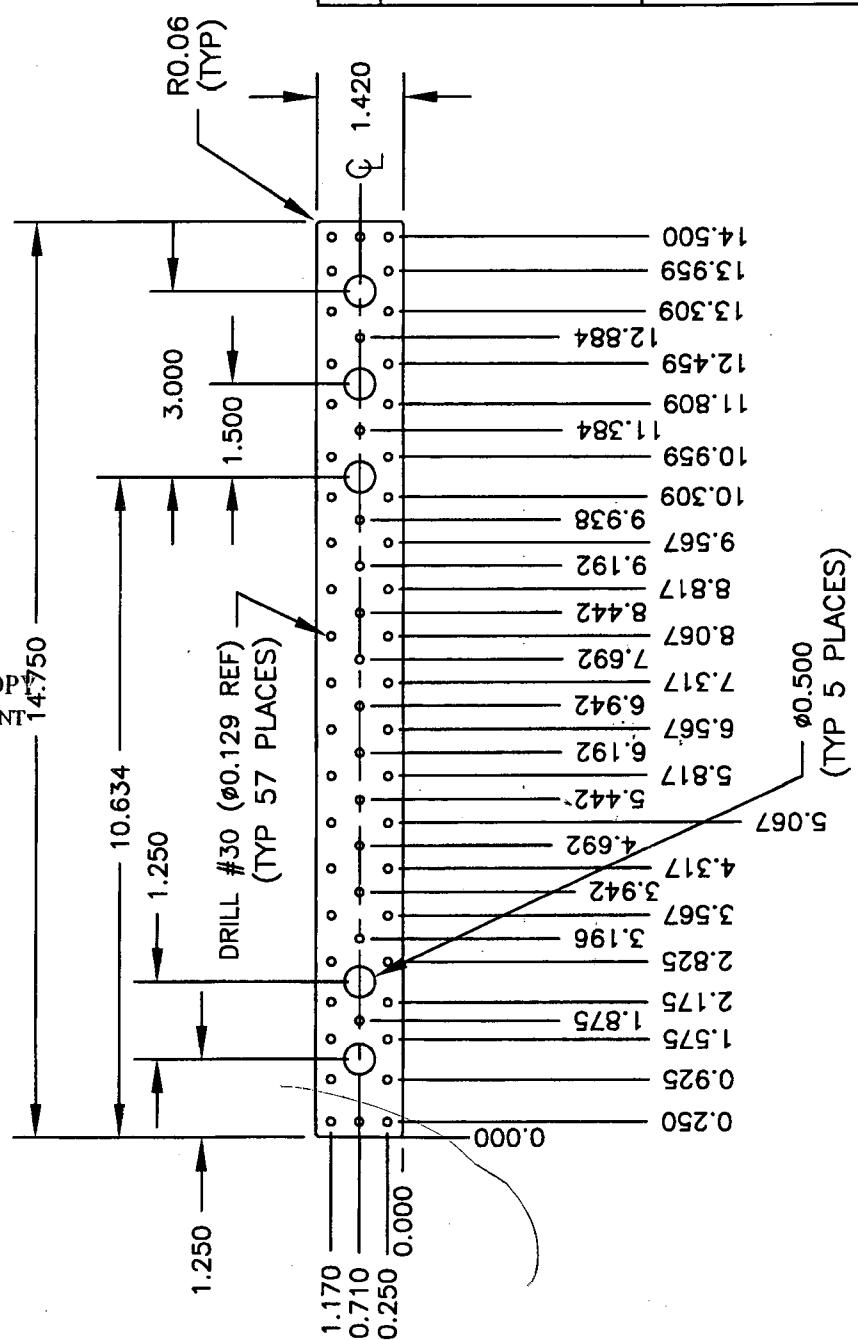


RELEASED
07.08.2014
PER ECN 959

DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
CHECKED <i>BS</i>	APPROVED <i>MM</i>	DRAWING NO. D3283	REV. E	SHEET 1 OF 2
DATE 07.06.01		TITLE DOUBLER	SCALE 1:3	
A	04.05.06	NEW ISSUE		
B	04.08.09	10.882 WAS 11.502		
C	05.03.16	CHANGE HOLE PATTERN FOR -1		
D	05.08.09	REDESIGN		
E	07.06.01	MISSING HOLE ADDED @ (7.692, 0.710)		

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED CO
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 111941

PL11033



D3283-1 DOUBLER

1) MATERIAL: 6061-T6, 0.063 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.063)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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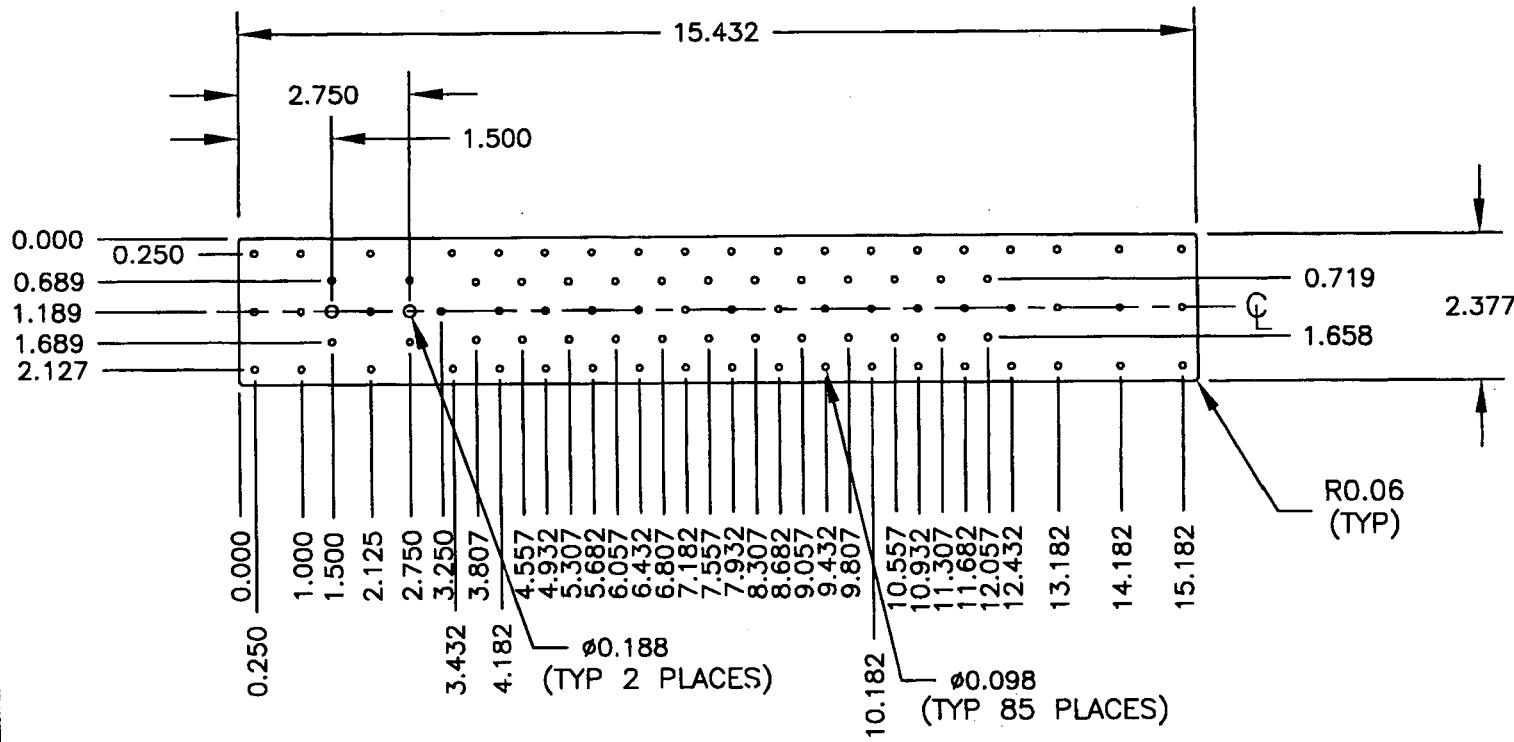
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DART

RELEASER
07-08-2014
PER ECN 959

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		PORT HADLOCK, WA		
CHECKED <i>fb</i>	APPROVED <i>MM</i>	DRAWING NO. D3283	REV. E	
DATE 07.06.01	TITLE DOUBLER	SHEET 2 OF 2	SCALE 1:3	



D3283-3 DOUBLER

- 1) MATERIAL: 6061-T6, 0.080 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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